Date: Monday, 1/23/2006 7:51:48 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: AFT X-TUBE EXT HEIGHT GEAR
Job Number	: 25583		
Estimate Number	: 10421		
P.O. Number	: N/A	**Part Number**	: D205596103
This Issue	: 1/23/2006 **S.O. No.** : N/A	**Drawing Number**	: D205-596-103 REV A
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LANDING GEAR	**Drawing Revision**	: A
Previous Run	: 25582	**Material**	: NA
Written By	:	**Due Date**	: 2/17/2006 **Qty:** 1 **Um:** Each
Checked & Approved By	:		
Comment	: Est Rev:G 05.06.10 Acid etch moved to Step 11 KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy D205-594 bluefile & type labels per PPP D205-596-103CHG001 KJ 06-02-24 ~~PER ATTACHED~~

Seq. #:	Machine Or Operation:	Description :
2.0	D2890	Aft Crosstube

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part number	Description	Batch
1	D2890	Aft Crosstube	B28491 DP 6-10-2

Seq. #:	Machine Or Operation:	Description :
3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

DP 6-10-2

1-Mark 30.21" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.

Seq. #:	Machine Or Operation:	Description :
4.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK
Inspect dimensions. Comformity check and sign off by engineering. 06.10.02

Seq. #:	Machine Or Operation:	Description :
5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-103 DP 6-10-11

2-Deburr & Inspect for surface damage. Polish cut surface.Scribe part # and batch # on one end of tube. 06-10-12 (1)

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/23/2006 7:51:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT X-TUBE EXT HEIGHT GEAR

Job Number: 25583 **Part Number:** D205596103

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

06-10-12 (1)

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
TOUCH UP Chemical Conversion Coat as per QSI 005 4.1

FC
a.m 06-10-12 (1)

8.0	SPRAY PAINTING	SPRAY PAINTING

Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2 M 06 10 16 (1)

9.0	QC14	Inspect Spray Paint

Comment: Inspect Spray Paint

06-10-17 (1)

10.0	D2856600	Abrasion Strip

Comment: Qty.: 21.1890 f(s)/Unit Total : 21.1890 f(s)
Pick:

Qty	Part number	Description	Batch
2	D2856-600(10.090")	Abrasion Strip	B24328 IT 06-10-19

11.0	D29401	Support

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part number	Description	Batch
2	D2940-1	Support	B25594 IT 06-10-19

12.0	MS2192028	Clamp

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part number	Description	Batch
4	MS21920-28	Clamp	M101684 IT 06-10-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes / No (circled: No) **DQA:** [signature] **Date:** 26/10/23

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/23/2006 7:51:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: AFT X-TUBE EXT HEIGHT GEAR

Job Number: 25583
Part Number: D205596103

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1
Install abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg D205-596-103. Torque clamps to 80-100 in lb. ZT 06-10-19 (1)

Seq. #:	Machine Or Operation:	Description :
14.0	QC5	INSPECT WORK TO CURRENT STEP

06-10-19 (1)

Comment: INSPECT WORK TO CURRENT STEP

Seq. #:	Machine Or Operation:	Description :
15.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D205-596-103
Location: NEV R 06/10/23 (1)

Seq. #:	Machine Or Operation:	Description :
16.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Inspection Level 21 06.10.23

Job Completion 10/23

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

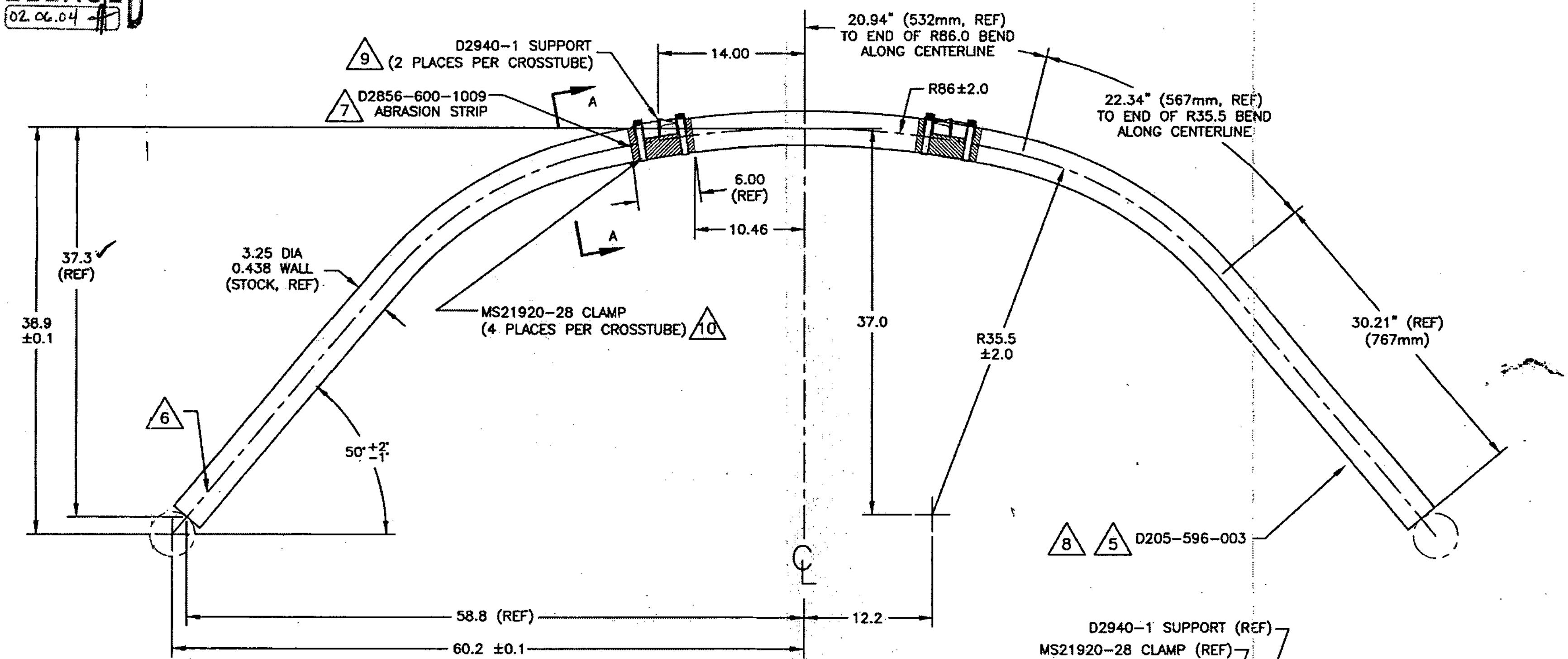
Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

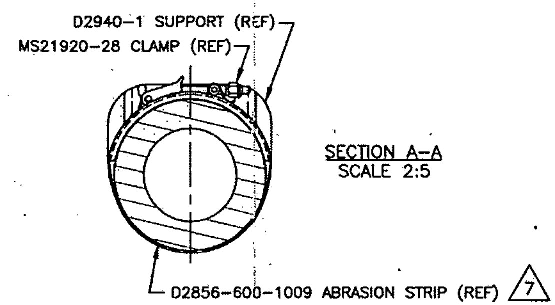
QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED 02.06.04





SECTION A-A
SCALE 2:5

GENERAL NOTES:
1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) MATERIAL: MANUFACTURE FROM D6008-180
FINISHED LENGTH = 146.98
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
4) PART IS SYMMETRIC ABOUT CENTERLINE
5) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
6) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
7) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2940-1 SUPPORT, PER QSI 035
8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
9) SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/-291 SEALANT (OPTIONAL)
10) TORQUE CLAMPS 80 TO 100 IN-LB

A	02.05.27	NEW ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D205-596-103 — REV. A — SHEET 1 OF 1
DATE 02.05.27		TITLE XTUBE ASS'Y (HI-HI AFT) — SCALE 1:10